Work Order ID 6023	Work	Order 1	ID 60239
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Page 1

Tuesday, June 29, 2010 11:49:43 AM

D4091-1

Accept



Setup Start



Revision ID:

Item Name:

Mounting Lug

Start Date:

Required Date: 7/6/2010

6/29/2010

Start Oty: 12.00 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date//

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Start

Stop



Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Draw Nbr

D4091 Α

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

Run

110

HAAS 1

HAAS CNC vertical machine #1

0.00

Memo

0.00

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: A(DWG REV:_

10/07/1B

DEBURR

Dart Aerospace Ltd W/O: WORK ORDER CHANGES PROCEDURE CHANGE Procedure Changes Proced

	O,L.	PROCEDURE CHANGE	Бу	Date	Giy	Prod Mgr	QC Inspector
				·			
Part No	·	PAR #: Fault Category: NC	R: Yes	No DQA	λ :	Date:	

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: ____

NCR:		W						
		Description of NC		Corrective Action Section B	Verification	Annuaval	Ammuoval	
DATE STEP		Section A	InitialAction DescriptionSign &Chief EngChief EngDate		Section C	Approval Chief Eng	Approval QC inspector	
						}		
	ı				3			

Work Order ID 60239

Page 2

Tuesday, June 29, 2010 11:49:43 AM

Item ID: Revision ID: D4091-1

Accept

Setup Start



Stop

Item Name: **Start Date:**

6/29/2010

Mounting Lug

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Required Date: 7/6/2010

Tooling:

Date:

Start Run



Approvals:

Process Plan:

Date:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

QC

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID Tool # Plan

Accept Qty

Code

Reject **Qty**

Reject Insp. Number

Stamp

QC8- Inspect parts - second check

0.00

onl 16/07/19

130

Quality Control

Memo

0.00

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

Hand Finishing

Dart	Aerospace	Ltd
w/o-		

W/O: WORK ORDER CHANGES										:	
DATE	STEP	PRO	OCEDURE CH	ANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·									
Part No: PAR #: Fault Category: NCR: Yes No DQA:								Date:			
	Res	olution:							Date:		
NCR:			WORK ORI	DER NON-CONFORI	MANCE (NCR)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Descriptio Chief Eng	n S	ign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector	
-											
		The state of the s									

Work	Order ID	60239
Tuesden	Inno 20 2010	11 40 43



Page 3 Tuesday, June 29, 2010 11:49:43 AM Item ID: D4091-1 Accept Setup Start **Revision ID:** Item Name: Mounting Lug Stop Start Date: 6/29/2010 **Start Qty: 12.00 Cust Item ID:** Required Date: 7/6/2010 Req'd Qty: 12.00 Customer: Reference: Process Plan: ____ Run Start Approvals: Date: Tooling: Date: Date:_____ Stop SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Description M114841 Accept Reject Work Center ID Reject Insp. **Run Hours** Code Qty Qty Number White Gloss(Ref.4.3.5.1) per QS1005 4.3-Alum Stamp 150 0.00 12 10-7-19 Powdercoat Memo aDEUT. 3200 0.00 Powder Coating FINISH 4:15. =) N 10/07/20 X12 160 QC3- Inspect Part Finish Memo 0.00 Quality Control 170 Identify as per dwg & Stock Location: 0.00 Packaging

Packaging

Memo

0.00

10-7 -20 5

Dart Ae		`,																																						
W/O:			W	ORK ORDER CHANGE	ES					•																														
DATE	STEP	PROC	PROCEDURE CHANGE							Approval QC Inspector																														
Part No	•	PAR #:	_ Fault Cat	egory:	NCR	: Yes I	No DQ	A:	Date:																															
	R	esolution:	Disposition:			N/C Clo	sed:		Date: _																															
NCR:		W	ORK OR	DER NON-CONFORMAL	NCE	(NCR)		, , <u></u>																															
DATE	CTED	Description of NC							V				Section B		Varification		Verification		Verificat		Verifica		Verifi		Approval	Approval														
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector																														
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Work Order ID 60239 Tuesday, June 29, 2010 11:49:43 AM													Page
Item ID: Revision ID: Item Name:	D4091-1 Mounting Lu	g		A	ccept					Setup		.,	
Start Date: 6/29/2010 Start Qty: 12.00 Required Date: 7/6/2010 Req'd Qty: 12.00 Reference:					Cust Item I Customer:			Stop					
Approvals: Process Plan:		an:	Date:		Tooling:	Da	ate:			Run	Start		
Sequence ID/	QC:	Oneseti	Date:		SPC (Y/N):	Da	ate:				Stop		
Work Center I	D	Operation Description QC21- Final Inspection -	Work Order Rei	lease	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	ot Rej Qty	•	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

Quality Control

Page 4

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES									
DATE	STEP	PROC	CEDURE CHANGE By Date Qty							Approval QC Inspector		
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Part No	•	PAR #:	_ Fault Ca	tegory:	_ NCR:	Yes N	lo DQ A	Date:				
-11	R	esolution:							Date:			
NCR:		W	ORK OR	DER NON-CONFORM	ANCE ((NCR)						
DATE	STEP	Description of NC	Corrective Action Section			0: 0	Verific		Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Section (on C	Chief Eng	QC Inspector		
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Picklist Print

Tuesday, June 29, 2010 11:49:47 AM

Work Order ID: 60239

Parent Item:

D4091-1

Parent Item Name: Mounting Lug

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Start Date: 6/29/2010

Required Date: 7/6/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	425.4002	0.1251	1.580211			/ }- ,-
					•		Ţ						

Lug Extrusion

Location	Loc Oty	Loc Code
MAT06	425.4001895	
43722	180	
r ~45800	245.400189	
\	•	•

1,5802(F) DIR 10/07/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CHA	- <u>- ,</u>	By Date Qty				Approval Chief Eng / Prod Mgr	Approval QC Inspector
									. Touring	
								,		
						·				
Part No	•	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	Date:	
		esolution:	Disposition: QA: N/0				osed:		Date: _	
NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			Sign & Verification Section C			Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Sect	ion C	Chief Eng	QC Inspector
,	i									
···										

DART AEROSPACE LTD	Work Order: 60239
Description: Mounting Lug	Part Number: 04091-1
Inspection Dwg: 4૦૧ Rev: 🗡	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	ie	Prototype					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
4.45	\$.030	4.451							
1.38	± , 03	1.377		*					
3.700	910. t	3.698							
.375	± .0\0	.376							
.625	\$.010	.623	✓						
.375	2.010. ±	.373	/						
. 293	± .010	.294	/						
1.91	± .03	191				,			
.69	÷ .03	.70							
0.257	1.006 - 001	.260	V			4 place			
,									
						÷,			
		~~~~~	<b></b>						

Measured by:	easured by: MW-		and	Prototype Approval:	N/A
Date:	10/07/18	Date:	10/07/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

**D4091-1 MOUNTING LUG** 

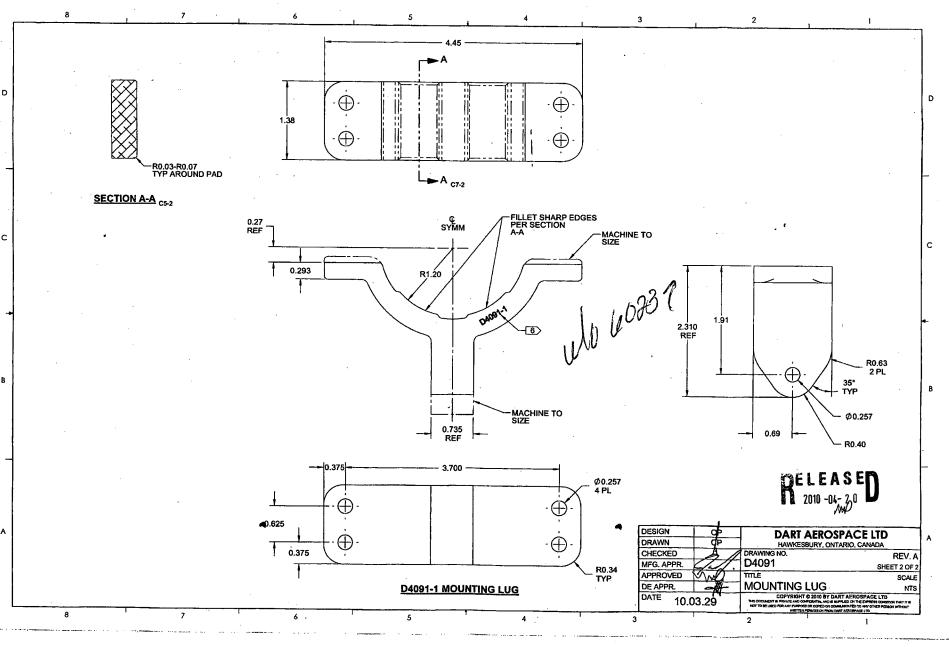
SHO" WAY RELACTO ENCINI 448NO UNCONTROLLE OF SUBJECT TO ASSESS Affice WITHOUT NOTICE WORK ORDER

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
7) WEIGHT: 0.31 lbs

A	NEW I	SSUE		<del> </del>			
REV.			DECORPORA	CP	10.03.29		
	<del></del>		DESCRIPTION	BY	DATE		
DESIG		CP	DART AFRO	CDACEL	TO		
DRAWN C		CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED		<b>A</b>	DRAWING NO				
MFG. APPR.		191	D4091		REV. A		
APPRO		fol f		SHEET 1 OF			
		TXWX	TITLE		SCALE		
DE APPR.			MOUNTING LUG		NTS		
DATE	40.	20.00	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DODAMENT IS PROVIDE AND COMPUTED OF THE COPYRIS CONSTITUTION THAT IT IS NOT TO BE USED FOR AMY PLAYOUS OR GOVED BY COMMUNICATED TO AMY OTHER PROGRAM WITHOUT THE PROPERTY PROPERTY OF THE PROPERTY				
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#### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval Approval** DATE **STEP** PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: _____ Resolution: _____ QA: N/C Closed: ____ Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval** Approval DATE **STEP Action Description** Sign & Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng



## **Dart Aerospace Ltd**

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W/O:		WORK ORDER CHANGES								* * *
DATE	STEP	PRO	OCEDURE CHAN	IGE	By Date Qty				Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #		PAR #:	Fault Categ	ory:	NCR: Yes No DQA:					· · · · · · · · ·
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DATE		Description of NC	Corrective Action Section B				Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C			Chief Eng	QC Inspector
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